

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012694**Date Inspected:** 05-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr.Wuzhi Chang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

This CALTRANS OSM Quality Assurance Inspector (QA) Surendra Prabhu was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG TRIAL ASSEMBLY

LIFT: 7-West -Panel Point (PP) #50~55.

This QA Inspector Randomly performed joint Inspection along with Caltrans QA Inspector Mr.Manoj Prabhune for the Panels flatness at Lift-7 West between PP#50~55. The flatness deformation was measured only at location which were accessible using available scaffolding. The following location is not comply with the contract document.

During random flatness inspection this Caltrans Quality Assurance Inspector (QA) observed a following Issue:

- The Deformation was measured to be approximately 22 mm in 2250 mm Maximum template size.
- The Segment and Panel Point no is 7CW-PP#54 Facing West at Crossbeam (CB) Side.

This QA generated a report on this date for the above issue and submitted to the Task Leader for further action.

WELDING INSPECTION REPORT

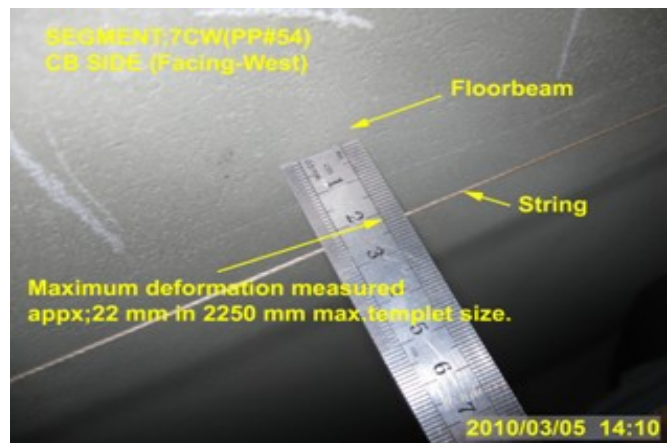
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The attached photographs provide additional detail.

Lift: 6 East line (PP #40~47)

This QA Inspector performed dimension check for the longitudinal diaphragm weld length from the cope hole to the weld termination point for OBG Lift: 6 East from PP#40 to PP#47 at E3 Location along with Caltrans QA Inspector Mr. Manoj Prabhune. The measured readings were data recorded, generated the report and submitted to the Task Leader for further action.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and Quality Control (QC) concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhu, Surendra	Quality Assurance Inspector
Reviewed By:	Miller, Mark	QA Reviewer
